

Date: Friday, 06/02/2009 11:29:00 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B FLOOR PROTECTOR (PASSENGER CABIN)
 Job Number : 45594
 Estimate Number : 13789
 P.O. Number :
 This Issue : 06/02/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 06/02/2009 Type : R&D THERMOFORMING
 Previous Run :
 Part Number : D38751
 Drawing Number : D3875-1 09.04.21
 Project Number : IN0002
 Drawing Revision : PROTOTYPE
 Material : To Be Determined
 Due Date : 16/02/2009 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : SUD 09.02.06
 Comment : Est. Rev. A 09.02.06 New Issue DL

Additional Product

PROTOTYPE
ENGINEERING
APPROVAL

Job Number:



Seq. #:

Machine Or Operation:

Description :

0.0

MLEXANS125

MLEX5118 90318 08

1/8" Lexan Sheet



M110566.



PTO →

Comment: Qty.: 8.0000 sf(s)/Unit Total : 16.0000 sf(s)
 1/8" Lexan Sheet 18.75

1.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

09/02/06 DL

2.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

09/02/06 DL

3.0

THERMOFORMING

THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3875-1 and folio (3875 Prototype) using tool DT 9435

Dwg. Rev. PROTOTYPE
 Folio Rev. A

09/02/06 DL

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

09/02/06 DL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector
09/04/06	O.O.	Material .118 textured hexan. Sample supplied by Sabee Do NOT DRAW MAT FROM STOCK. AS per drawing <i>[initials]</i>	<i>[initials]</i>	09.04.16.		<i>[initials]</i> 09.04.16	<i>[initials]</i> 16.04.16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 06/02/2009 11:29:00 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FLOOR PROTECTOR (PASSENGER CABIN)

Job Number: 45594

Part Number: D38751

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BB 09/02/06

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

09/02/06 Wk.

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/04/16 X

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.04.21

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ENG'S testing

FOR ENGINEERING USE ONLY

09.04.21

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09.04.22 Prototype

Job Completion



W 09.06.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	45594
Description: 2068 FLOOR PROTECTOR CABIN	Part Number:	D3875-1
Inspection Dwg: D3875 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

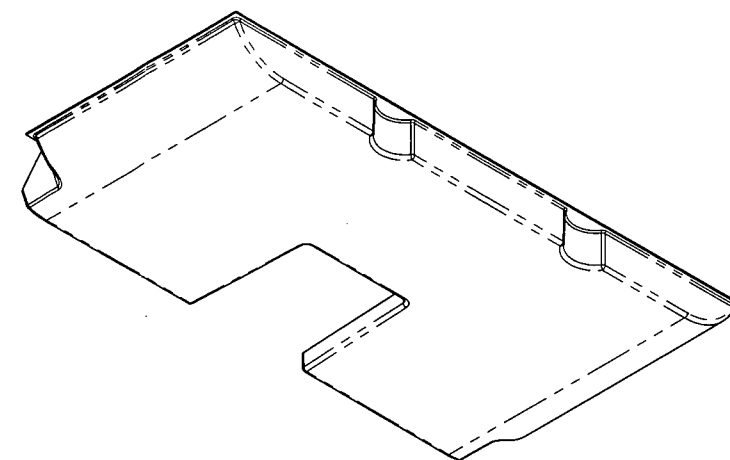
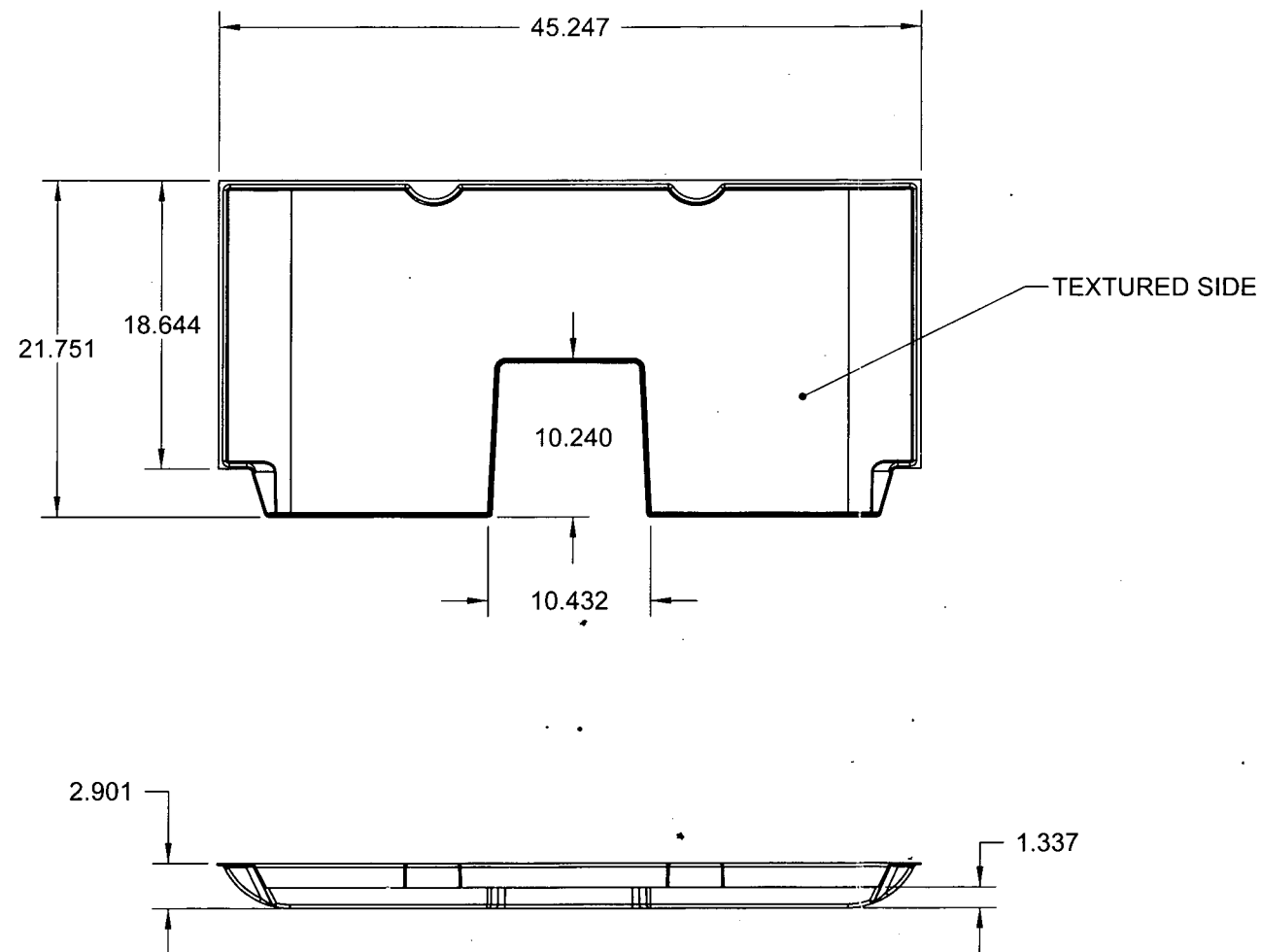
Measured by: BB	Date: 09/04/16
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
45.247		45.30				Revise
18.6		18.875				Revise
21.8		21.8	✓			
1.4		1.38	✓			
2.9		2.892	✓			
.050	m.d	.915	✓			
.060	m.d	.080	✓			

Measured by: BB	Date: 09/04/16
Audited by: [Signature]	Date: 09.04.16
Prototype Approval: [Signature]	Date: 09.04.20

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



*SUPERCEDED
BY ON
09.04.09 RH*

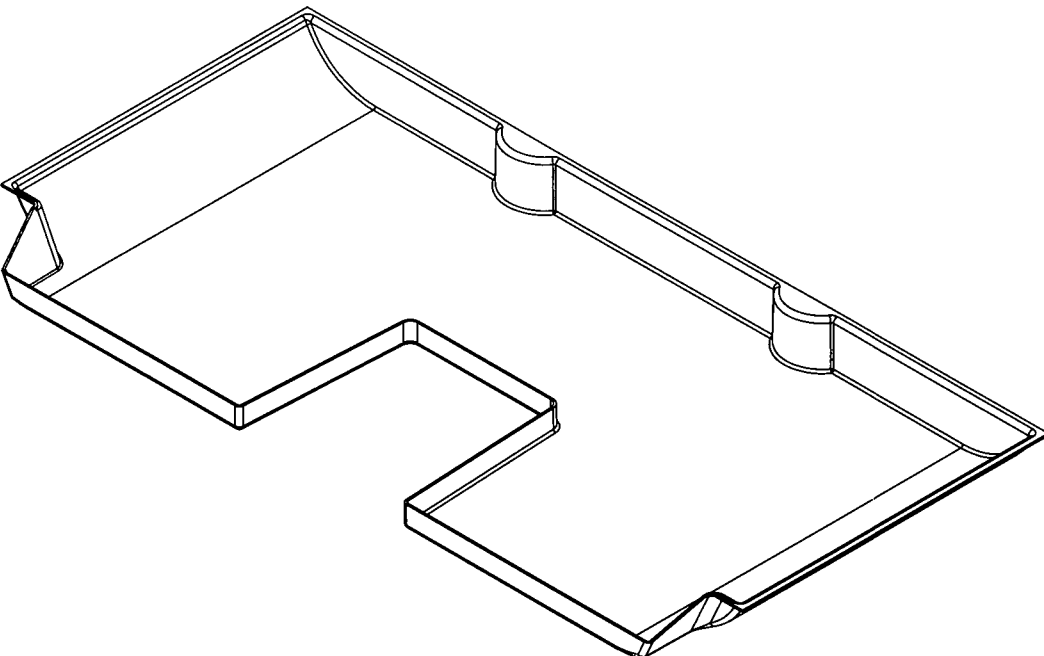
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.02.04 RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45594

D3875-1 FLOOR PROTECTOR

- NOTES:**
- 1) MATERIAL: LEXAN 9034, 0.118" THICK
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3875-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT _____ PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: _____" UNLESS OTHERWISE NOTED

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RH</i>		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3875	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	09.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3875-1 FLOOR PROTECTOR (206B)

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.04.09 *PH*

SUPERCEDED
09.04.21 *PH*

- NOTES:
- 1) MATERIAL: LEXAN 90318, 0.118 THICK, 112-CLEAR
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3875-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 4.0 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT _____ PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.060" ELSEWHERE

A	NEW ISSUE		PH	09.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>PH</i>			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3875	SHEET 1 OF 2	
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DE APPR.		FLOOR PROTECTOR (206B)	NTS	
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SABIC Polymershapes

سابك
sabic

INVOICE NO.	0085310/M
INVOICE DATE	21.01.09
TAKEN BY	melkertd
G.S.T. REG. NO.	856372750RT0001
CARRIER	

INVOICE

PST 85637 2750 TR000

SOLD TO: DART AEROSPACE LTD

1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7
Canada

SHIP TO: DART AEROSPACE LTD
1270 ABERDEEN ST.
ATTN: LINDA LACELLE
HAWKESBURY ON K6A 1K7
Canada

A/C 22.3

CUSTOMER DARAER		SHIP VIA EPIC		TAX LIC 1 CHARGE GST		TAX LIC 2 6112-5207		INVOICE TERMS NET 30 DAYS		SALES ORDER O85498		PAGE 1		A/C 22.3 WHS. 99	
CUSTOMER P.O. SAMPLE		SHIP DATE 21.01.09		FREIGHT TERMS PREPAID		SALES REP. WADE DIXON		S.D.N. 01		BILL OF LADING		Sch. Date 21.01.09		Sales Office 99	
LN	PRODUCT		ORDER	B/O	SHIP	SKU	DESCRIPTION			PRICE	PER	EXTENSION			
001	11201655		1	0	1	SHT	*** SAMPLE REQUEST *** 90318-112 PROTECT A GLAZE .118 X 60 X 96			1	.00	SHT	0.00		
002	0000005		1	0	1	EA	THANK YOU FOR SELECTING SABIC POLYMERSHAPES GST PAYABLE @ 5%			1	.00	EA	0.00		
							PLEASE PAY THIS AMOUNT						0.00		
							=====								
							Balance Outstanding						0.00		
							**** PAID ****								
							RECEIVED JAN 27 2009								

							*** IF YOU ARE NOT CURRENTLY RECEIVING OUR INVOICES ***								
							*** VIA EMAIL OR FAX, PLEASE SUPPLY US WITH AN EMAIL ***								
							*** ADDRESS OR FAX NUMBER . FAX TO 905-789-3161 ***								

							*								

PLEASE Remit To: SABIC Polymershapes 9150 Airport Road Brampton ON L6S 6G1

Phn : (613)745-7043 Fax : (613)745-4291

NO GOODS TO BE RETURNED WITHOUT APPROVAL FROM US. ALL DISCREPANCIES MUST BE REPORTED WITHIN 3 DAYS.

Receiving Report

Date: 09/10/20

Batch No: 110566

Supplier: Sabic Poly.

Dart P/O: ~~7702~~ SAMPLE

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☐
 Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☐ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☐ N/A ☐
 Shipment Complete: Yes ☐ No ☐ N/A ☐
 QCS Inspection ☐ N/A ☐
 Work Order ☐ N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	<u>Dimple</u>	<u>Dimple</u>				

Initials of receiver (if shipment OK) Level 12 CX

Production/Admin:

Date

Received/Costing

Initial

Location

H:\FORMS\Purchasing\approved purch\RECREPORT R v D

THANK YOU FOR SUBMITTING
 SPENT POLYMERIZATION

DESCRIPTION WHAT BE REPORTED WITHIN 1 DAY
 UNDER NO. 110566, MARKED BY ALL DISCREPANCIES

SABIC
Innovative
Plastics™

سابك
sabic

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: Jan. 21, 2009

YOUR PURCHASE ORDER: N/A

OUR SHIPPER NO: 085498

INVOICE NO: 0085310

SABIC POLYMERSHAPES LINE ITEM # 001

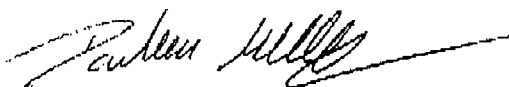
QUANTITY: 1 SAMPLE SHEET

DESCRIPTION: 90318-112 - PROTECT A GLAZE - .118 X 60 X 96

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: UL -94 -HB

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

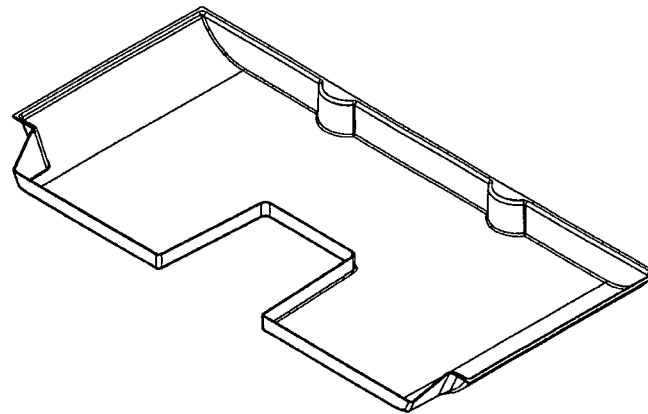
AUTHORIZED REPRESENTATIVE SIGNATURE



DARLEEN MELKERT
INSIDE SALES REPRESENTATIVE

1450 Old Times Road
Unit 519
Ottawa, Ontario
K1B 5L3

T: 613-745-7043
F: 613-745-4291
E: darleen.melkert@sabic-ip.com
www.sabic-ip.com



D3875-1 FLOOR PROTECTOR (206B)

SUPERLEDED ON
09.04.22 RH

Prototype 09.04.21
RH

NOTES:

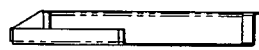
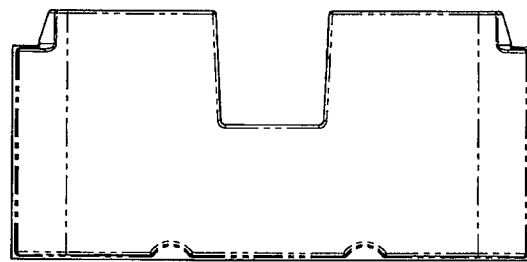
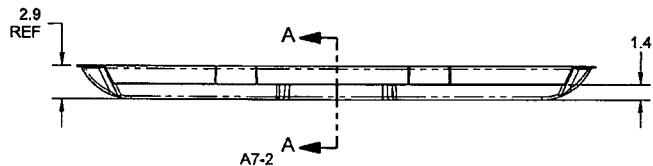
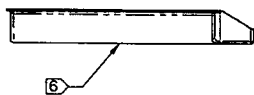
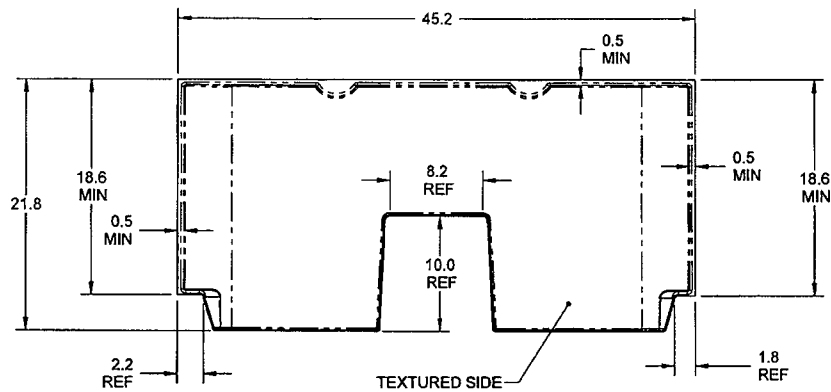
- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3875-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9475 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.045" ELSEWHERE

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.29		

DART AEROSPACE LTD		REV. A
HAWKESBURY, ONTARIO, CANADA		
DRAWING NO.	D3875	SHEET 1 OF 2
TITLE	FLOOR PROTECTOR (206B)	SCALE
DATE		NTS

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8 7 6 5 4 3 2 1



SECTION A-A B4-2

D3875-1 FLOOR PROTECTOR (206B)

SUPERCEDED BY
09.04.22 RH

Prototype
09.04.21 RH

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3875	SHEET 2 OF 2
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8 7 6 5 4 3 2 1